

Work Order ID 133948

133948

Page 1

Tuesday, June 23, 2015 3:25:13 PM

Item ID: D4777-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Rod End Bearing

Start Date: 7/03/15 Start Qty: 8.00 *8* Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: MLS Date: JUN 24 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4777	A

100 PURCHASING 0.00

100

Purchasing Memo 0.00

Purchasing Issue P/O: 28934

Purchase Part Number: 59915K274 Supplier: Mc Master Carr

Certificate of conformity is required

CL 13/06/24 8

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging Memo 0.00

Packaging Ensure certificate of conformity is attached

8x 8015-06-26

120 QC6- Inspect dimensions to drawing 0.00

120

QC Memo 0.00

Quality Control

(B)

DAS 38 9-89

JUN 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 133948

133948

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Tuesday, June 23, 2015 3:25:13 PM

Item ID: D4777-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rod End Bearing
 Start Date: 7/03/15 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>5127</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

CL 151061268

MLJ JUN 29 2015

MLJ JUN 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Tuesday, June 23, 2015 3:25:12 PM

Page 1

Work Order ID: 133948

133948

Parent Item: D4777-1

D4777-1

Parent Item Name: Rod End Bearing

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
59915K274		Purchased		No		110	Each	0.0000	1	8			

59915K274

Rod End Bearing

8x 8p15-de-28

DQA: _____ Date: _____



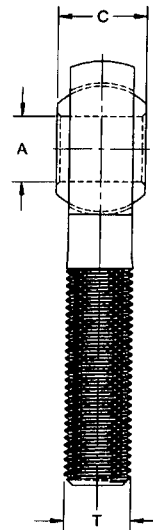
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

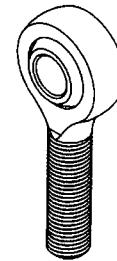
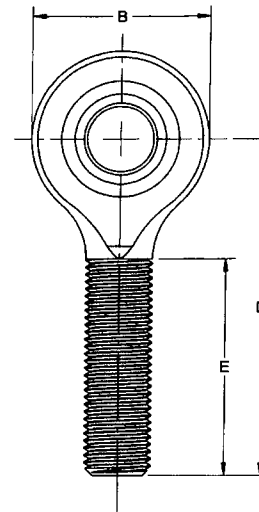
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

SPECIFICATION CONTROL DRAWING



ROD END BEARING



SHOWN BY
REF 195
ENGINE 1610
UNCONTROLLED
SUBJECT TO
WITHIN
WORK
NO. 133948 MLC
1506-24

DART P/N	HOUSING MATERIAL	A	B	C	D	E	T (THREAD SIZE)	SUGGESTED SUPPLIER	SUGGESTED SUPPLIER P/N
D4777-1	STAINLESS STEEL	Ø0.38	1.00	0.500	1.94	1.25	3/8-24 (RIGHT HAND)	MC MASTER CARR	59915K274

RELEASED
2013-08-14

A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.08.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D4777
REV. A
SHEET 1 OF 1
TITLE ROD END BEARING
SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28934

Purchase Order Date 6/24/2015

PO Print Date 6/24/2015

Page Number 2 of 4

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$109.44

4 97787A661

Expandable Pin

6/26/2015

Yes

6/26/2015

6.00

Each

\$114.68

\$688.08

AS PER DWG D4711 REV. C
B133900

Line Total: \$688.08

5 59915K274

Rod End Bearing

6/26/2015

Yes

6/26/2015

8.00

Each

\$17.14

\$137.12

AS PER DWG D4777 REV. A
B133948

Line Total: \$137.12

6 71500-30

1326A11 PIN GAUGE

6/26/2015

Yes

6/26/2015

1.00

Each

\$81.70

\$81.70

Note:

6/24/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Jean-Luc
Eric.L

Purchase Order
PO28934

Order Placed By
Chantal Lavoie

McMaster-Carr Number
5170960-03

Page 1 of 1

06/24/2015

Line	Product	Ordered	Shipped
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B134006	10 Each	10 ✓
2	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length Your Part Number: B134005	10 Each	10 ✓
4	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Your Part Number: B133900	6 Each	6 ✓
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Your Part Number: B133948	8 Each	8 ✓
6	2326A11 Plug Gauge Set, Class Z, .0110"-.0600" Range, Go Gauge, 50 Pieces Your Part Number: 71500-30	1 Each	1
7	2846A129 Single-Flute High-Speed Steel Countersink, 82 Degree Angle, 1-1/4" Body Diameter, 1/2" Shank Diameter Your Part Number: 71500-30	1 Each	1
8	91732A211 18-8 Stainless Steel Standard Helical Insert, 10-24 Internal Thread, .285" Length, MS122120, Packs of 10 Your Part Number: 71500-15	30 Packs	30
9	4714A405 High Performance Multipurpose Sanding Belt, 50 Grit, 3/4" Wide, 20-1/2" Long Your Part Number: 71500-15	25 Each	19

Shipped separately from our Chicago warehouse on 06/24

9	4714A405 High Performance Multipurpose Sanding Belt, 50 Grit, 3/4" Wide, 20-1/2" Long	25 Each	6
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McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 33018649
Purchase Order: PO28934
Release:
McMaster-Carr Number: 5170960-03

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 24-Jun-2015

FOB: ORIGIN

Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:
Shipping Jean-Luc
Attention: Eric.L

Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick B134006 Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	10 EA	\$17.24	\$172.40
2	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length B134005 Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	10 EA	\$3.01	\$30.10
4	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length B133900 Country of Origin: United States Schedule B #: 731829 ECCN #: 9A991 NLR	6 EA	\$114.68	\$688.08
5	59915K274 PTFE Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread B133948 Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
6	2326A11 Plug Gauge Set, Class Z, .0110"-.0600" Range, Go Gauge, 50 Pieces 71500-30 Country of Origin: United States Schedule B #: 903180 ECCN #: EAR99 NLR	1 EA	\$81.70	\$81.70
Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department. These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.				

SP15-06-26

Shipping Weight (in kgs): 3

Number of Packages: 1

Invoice Amounts:

Merchandise Amount: \$1,323.82
Canadian GST/HST: \$173.83
Shipping Charges: \$13.40
Total (in USD): \$1,511.05

Package Dimensions:

47 X 21 X 17 CM = .017 CUBIC M

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Remit payment to:
(by mail)
McMaster-Carr Supply Company
PO Box 7690
Chicago, IL 60680-7690 USA

(by wire transfer)
Bank of America Illinois
231 S LaSalle
Chicago, IL 60697
ABA 071000039 Account 86666-02021
SWIFT BOFAUS3N

Authorized Signature:

Date:

24-Jun-2015

Name: Sarah Weinberg

Title: Operations Mgr.